

Work Order ID 73389

Wednesday, August 31, 2011 3:03:19 PM



Page 1

Item ID: D2274

Accept



Setup Start



Revision ID:

Item Name: Radius Block

Stop



Start Date: 8/31/2011 Start Qty: 200.00

Required Date: 9/16/2011 Req'd Qty: 200.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

CL

Date:

11/08/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2274	Rev F								
100		0.00							
	SHEAR								
Shear	Memo	0.00							
Shear	blanks 9.00" long +/- 0.030" <input type="checkbox"/> Note: 1 blank makes 9 pieces								
110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per folio D2274								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B.A. 11/09/11

234

φ

CL 11/09/12

B.A. 11/09/13

234

φ

CL 11/09/12

234

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Radius Block

Start Date: 8/31/2011 Start Qty: 200.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 200.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		22 11.9.13					
140 Small Fab Small Fab	Small Fab Memo Tumble <input type="checkbox"/> Deburr any rough edges after tumbling	0.00 0.00						1B 11-9-14	(234)
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00						234	BL 11-9-15.

W/O:		WORK ORDER CHANGES					
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Item ID: D2274	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Radius Block				
Start Date: 8/31/2011	Start Qty: 200.00		Cust Item ID:	
Required Date: 9/16/2011	Req'd Qty: 200.00		Customer:	
Reference:				

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

234XPM-11/09/15

170	Identify as per dwg & Stock Location: <u>510</u>	0.00							
Packaging	Memo	0.00							
Packaging									

SP 11-09-15

180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/9/16

MF
11-09-15

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Picklist Print

Wednesday, August 31, 2011 3:03:17 PM

Page 1

Work Order ID: 73389

Parent Item: D2274

Parent Item Name: Radius Block



Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP H□00.05.18□Added inspection level 8□EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	90.7500	0.0916	19.28421			



6061-T6 Bar .750 x .125

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT001	90.75	
116406	2.75	
117653	48	
→ 118641	40	

19.54

D.A 11/09/01

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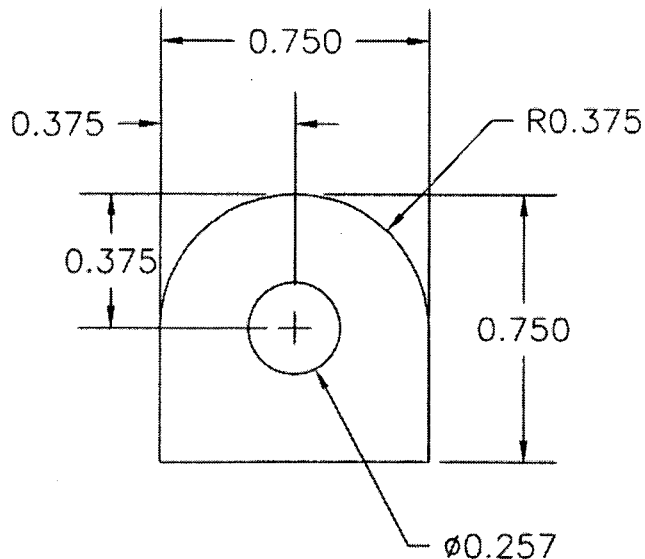
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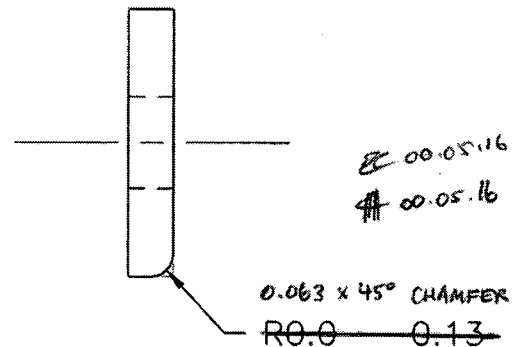


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MD</i>	APPROVED <i>KE</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/18 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73387
C21108131



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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